Late: User: Friday, 24/10/2008 3:31:27 PM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 42944

Job Number **Estimate Number** : 11534

P.O. Number

This Issue

Prsht Rev.

First Issue

Previous Run

: 24/10/2008

: 33896

: NC

: //

Type

S.O. No. :

: SMALL /MED FAB

Drawing Name

Part Number

: D30401 - D3040 REV B

: MOUNTING LUG

Drawing Number Project Number

: N/A

Drawing Revision

Material

Due Date

: 07/11/2008

Qty:

30 Um:

Each

Written By Checked & Approved By

Comment

: Est:B 01.11.08

Revised Step 2 and Added Inspection Level 21 S

Now on WaterJet 07-03-07 JLM Est Rev:C

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M6061T6B0187X04000



6061-T6 Bar .178 x 4.00



Comment: Qty.:

0.3718 f(s)/Unit Total:

11.1542 f(s)

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 alum plate 0.188" thick

Batch: 106652

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3041

Dwg Rev:_ Prog Rev:_

B8-16-10



2-Deburr if necessary

3.0

QC2

B8-11-10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

OC8



ECOND CHECK





Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: WA



8.11.12

Dart Aerospace Ltd

		— - - -								
W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				~~						
				•						
Part No:		PAR #:	Fault Categ	ory:N	ICR: Yes	No DQ	A:	Date: _		
Resolution:			Disposition	QA: N/C Closed: Date:						
NCR:		,	WORK ORDE	R NON-CONFORMANC	CE (NCF	7)				
		Description of NC		Corrective Action Section B		Verific	cation	ation Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign and Date	& Sect	ion C	Chief Eng	QC Inspector	
	-									
								ļ		

Date: User: Friday, 24/10/2008 3:31:27 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 42944

Part Number: D30401

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE



ECTION/W/O RELEASE

Job Completion



MF 08-11-12

Dart	Aeros	pace	Ltd
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Dart Ae	rospace Ltd							
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•					
Part No	:	PAR #:	Fault Category:	NCR: Yes No DQA:			Date:	
	Resolution	n:	Disposition:	QA: N/C (Closed:		Date: _	
NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
								T

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E	3	Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
						٠				

DART AEROSPACE LTD	Work Order:	42944
Description: Mounting Lug	Part Number:	D3040-1
Inspection Dwg: D3040 Rev: B		Page 1 of 1

	riko	AKTICLET	NOFECII	ON CH	ECKLIST		
	х	First Art	icle	Prof	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	С	omments
Ø0.257	+0.006-0.001	1,360	× ·				
3.413	+/-0.010	3.407	×				
3.186	+/-0.010	3,188	لا				
3.364	+/-0.010	3.360	æ				
0.188	+/-0.010	, 190	X				
	`			11			
Measured by:	# 2	Audited by:	mm/		Prototype App	roval:	N/A
Date:	8-10-11	Date:	1111111	1		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.09.06	New Issue	KJ/JLM ,	R
		<u> </u>	() ()	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
							·				
	F										
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	\ :	_ Date: _					

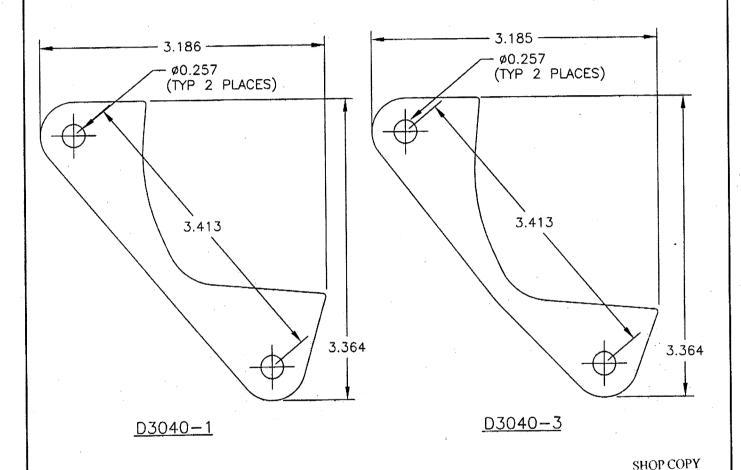
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
								}		
			!	·						
				,						



DESIG	n P	DRAWN BY	DART AEROSPACE US	A, INC.
CHEC	KED W	APPROVED.	DRAWING NO.	REV. B
	4	4	D3040	SHEET 1 OF 1
DATE			TITLE	SCALE
01.0	09.04		MOUNTING LUG	1:1
Α		01.06.27	NEW ISSUE	
В		01.09.04	CHANGED PROFILE 5 DEGREES	3





NOTES

RETURN TO ENGINEERING UNCONTROLLED COPY

MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"

SUBJECT TO AMENDMEN

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK (REF M6061T6S.188)

FINISH: NONE

BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

Dait Ac	- Ospaci	5 LIU							
W/O:			WORK ORDER CHANGES						
DATE STEF		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	gory:	_ NCR : Yes	No DQ	A:	Date:	
Resolution:			Disposition	Disposition: QA:				Date: _	
NCR:		V	VORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng			cation ion C	Approval Chief Eng	Approval QC Inspector
			Office Ling	One Eng					
					;				